

Work Order ID 118979

May-23-14 11:40:08 AM

118979

Page 1

Item ID: D3594-043

D3594-043

Accept

N900040100

Setup Start

NS1

Revision ID:

B118979

Stop

NS2

Item Name: Floor Doubler Assembly, LH

Start Date: 5/05/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 20.00

20

Customer:

Reference:

[Handwritten Signature]

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3594

Rev B

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO **24388**

1-Cut as per Dwg D3594

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

CZ 14/05/28 20

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

P44/6/18 (20)

Work Order ID 118979

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Page 2

May-23-14 11:40:08 AM

Item ID: D3594-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Doubler Assembly, LH
 Start Date: 5/05/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC6- Inspect dimensions to drawing	0.00							
125									
QC	Memo	0.00							
Quality Control									
				DAS 27 9-89 14/6/20		20			
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	C'SINK AS PER DWG D3594								
						20x			14/06/23
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
						20			

DAS
36
9-89

Work Order ID 118979

May-23-14 11:40:08 AM

118979

Page 3

Item ID: D3594-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Floor Doubler Assembly, LH

Stop ***NS2***

Start Date: 5/05/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

20 7/14/23

160 QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

20x 14/06/23

DAS
3f
9-89

170 Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

Install Nut Plates As per Dwg D3594

20x 14/06/23

DAS
3f
9-89

Work Order ID 118979

118979

Page 4

May-23-14 11:40:08 AM

Item ID: D3594-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Doubler Assembly, LH
 Start Date: 5/05/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				18			
									PTC →
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>STEON</u> Memo	0.00 0.00				18			
									DAS 28 9-89 JUN 26 2014
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
									14/11/4 18 mf 14-6-20

Picklist Print

May-23-14 11:40:07 AM

Work Order ID: 118979

118979

Parent Item: D3594-043

D3594-043

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 20.00

Required Qty: 20.00

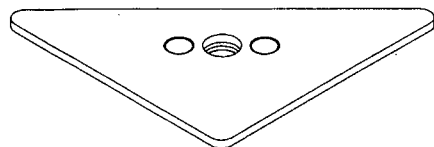
Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			170	sf	382.5600	0.51	11			
M6061T6S 080										**	C214/06/10		
6061-T6 .080 Sheet											m129439		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				382.56					
				m126309				130.52					
				m126350				13.34					
				m128903				238.7					
MS20426AD4-4		Purchased	No			100	Each	2,954.000	2	40			
MS20426AD4-4										**	14/06/23		
Rivet											DAS 36 9-89		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				210					
				129090				210		40			
				ST334				2744					
				125445				2744					
MS21069-5		Purchased	No			170	Each	36.0000	1	20			
MS21069-5										**	14/06/23		
Anchor nuts											DAS 36 9-89		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST317				36					
				m126274				1		1			
				m128560				25		19			
				m129198				10					

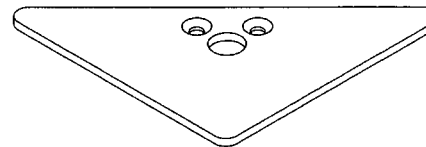
M6061T6S 080
6061-T6 .080 Sheet

MS20426AD4-4
Rivet

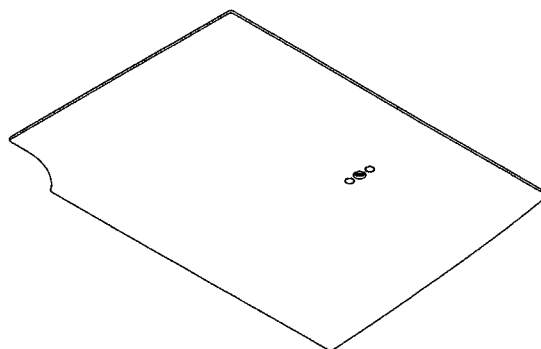
MS21069-5
Anchor nuts



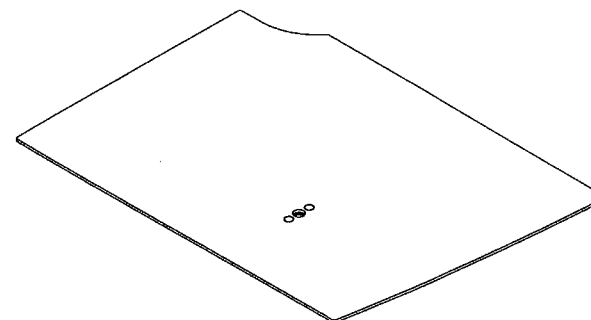
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



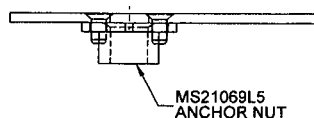
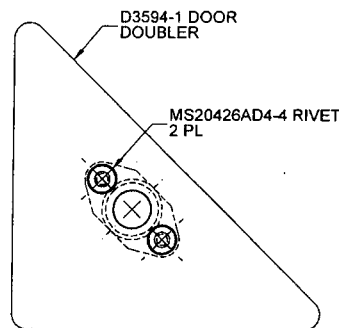
D3594-044 FLOOR DOUBLER ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **118979** *ML5*
14-05-07

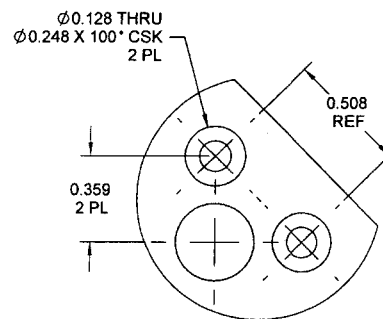
RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

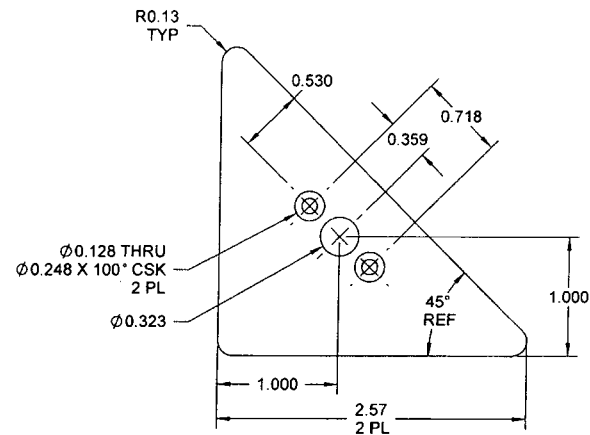
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



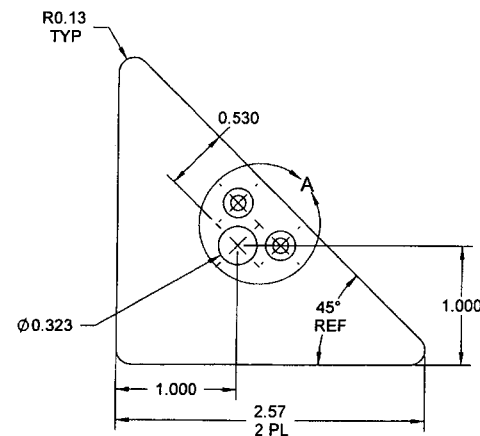
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

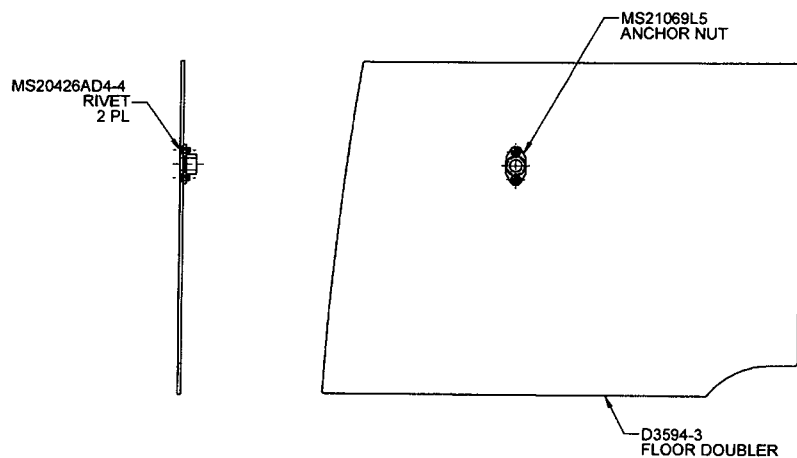
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

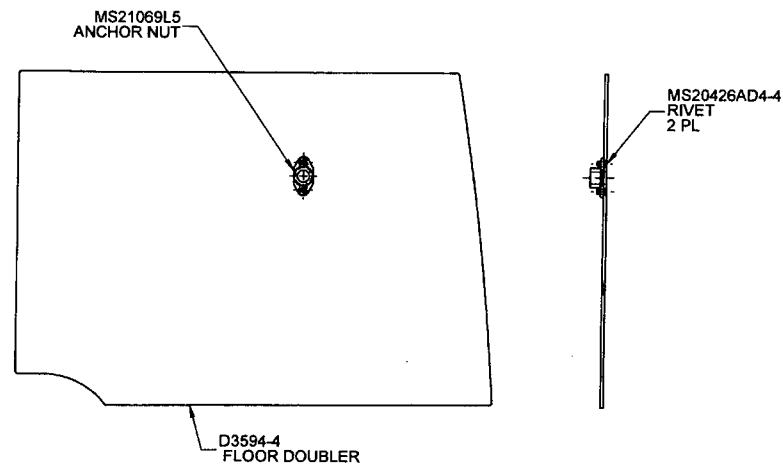
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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RELEASED
08-06-26-14

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3594
MFG. APPR.		REV. B SHEET 3 OF 4
APPROVED		TITLE DOUBLER
DE APPR.		SCALE NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

RELEASED
108-06-25-12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24388

Purchase Order Date 5/28/2014
PO Print Date 6/10/2014

Page Number 2 of 5

Order From :

VC-TPI001

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

					Line Total:	\$60.00
4	118979	D3594-3 FLOOR DOUBLER	6/20/2014	20.00	\$3.00	\$60.00
			Yes			
			6/20/2014			
CUT AS PER DWG D3594						
					Line Total:	\$60.00
5	119559	D3208-7 FILLER	6/20/2014	20.00	\$1.36	\$27.20
			Yes			
			6/20/2014			
CUT AS PER DWG D3208						
					Line Total:	\$27.20
6	115157	D2935 SADDLE SPACER	6/20/2014	40.00	\$1.75	\$70.00
			Yes			
			6/20/2014			
CUT AS PER DWG D2935						
					Line Total:	\$70.00

Note:

6/10/2014

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6152
Date: 2014-06-17
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24388	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-06-18
Tracking No.:	

Item No.	Unit	Description	Quantity
d2278	Chaque	d2278 step leg	50
d3065-5	Chaque	d3065-5 step leg	80
d3594-4	Chaque	d3594-4 floor doubler	20
d3594-3	Chaque	d3594-3 floor doubler	20
d3208-7	Chaque	d3208-7 filler	20
d2935	Chaque	d2935 saddle spacer	40
d3066-1	Chaque	d3066-1 spacer	80
d3065-5	Chaque	d3065-5 step leg	80
d3578-1	Chaque	d3578-1 doubler	40
d3594-5	Chaque	d3594-5 doubler	24

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days